

83147

Page 1

N900040100

Setup Start ***NS1***

Stop *NS2*

2

~

Reference:

Run Start *NR1*

Date:

Date:

Stop *NR2*

Draw Nbr	Revision Nbr
D412-711-101	A

0.00

100

Memo

Photocopy bluefiles and create labels
for PPP D412-711-101 Change 002

0.00

0.00

110

HAND FINISHING THERMOFORMING

Memo

Set up Machine as per folio FTA 077 and D711W program using mould DT9640

0.00

0.00

120

HAND FINISHING THERMOFORMING

Memo

Cut Blanks to 37.5" by 43"

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83147

83147

Page 2

April-13-12 10:34:11 AM

Item ID: D412-711-101

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Bubble Window

Start Date: 13/04/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 27/04/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	THERMOFORMING MACHINE								
Thermoform	Memo	0.00							
Thermoforming Machine	Thermoform as per Dwg. D412-711-101 using DT 9640 and Folio FTA 077 A. Dwg. Rev. X Folio Rev.								
140		0.00							
140	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control	1) Check Surface finish for undesired marks, voids, dimples etc.2) Check depth of bubble to ensure conformity to drawing tolerances.								
150		0.00							
150	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

12/05/15

PTO →

12/05/15

12/05/15

W/O: 83147		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D412-711-101 PAR #: _____ Fault Category: thermoforming NCR: Yes No DQA: ok Date: 12/05/28
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: ok Date: 12/5/28

NCR: 12/14/15		WORK ORDER NON-CONFORMANCE (NCR) 446.87						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/05/15	130	Scrap First Window Sheet Ripper Sheet damaged + cracked R.C. mat. Defect.	J 12/05/16 BS2042	Scrap + Destroy AMB Roly. m170972	BB 12/05/16 J 12/05/16	J 12/05/16 BS2042	J 12/05/16	

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83147

83147

Page 4

April-13-12 10:34:11 AM

Item ID: D412-711-101 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Replacement Bubble Window
 Start Date: 13/04/2012 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 27/04/2012 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
185 *185* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00				(A2)			
190 *190* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00		Reo C		(2)		10/5/12	
200 *200* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						12/5/23	

MLJ 12/05/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-13-12 10:34:15 AM

Page 1

Work Order ID: 83147

83147

Parent Item: D412-711-101

D412-711-101

Parent Item Name: Replacement Bubble Window

Start Date: 13/04/2012

Required Date: 27/04/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 06-02-01 JLM
Manufacture in-house 10/06/28 DL

IPP Rev. B.

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MACRLICS.236

Purchased

No

sf

237.3854

42.66667

MACRI ICS 236

Plexiglass G .236"

**

Bar 2/00/15

Location

Loc Qty

Loc Code

therm

237.3853524

101.846474

135.538878

119347

120972

21.333

42.666

\$63.999

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	83147
Description: Replacement Window		Part Number:	D412-711-101
Inspection Dwg: D412-711-101 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u> "				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: <u>B</u>	Date: <u>12/05/15</u>
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.00	+/-0.030	2.05"	✓		ULTRA	
1.73	+/-0.030	1.76"	✓		ULTRA	
1.98	+/-0.030	1.98"	✓		ULTRA	
1.50	Min	1.53"	✓		ULTRA	
0.090	Min	0.106"	✓		ULTRA	
0.070	Min	0.101"	✓		ULTRA	
0.050	Min	0.089"	✓		ULTRA	
15.0	+/-0.5	15.13"	✓		TAPE DL-01	

Measured by: <u>BK</u>	Date: <u>12/05/16</u>
Audited by: <u>S</u>	Date: <u>02/05/16</u>
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
B	10.10.08	New Issue	KJ	

